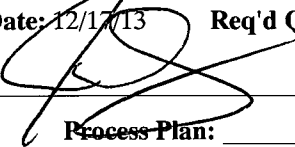


Work Order ID 110145




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


Page 1

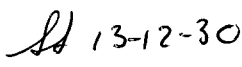

December-17-13 9:16:10 AM

Item ID:	D2893-1	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Support					
Start Date:	12/17/13	Start Qty: 12.00	*12*	Cust Item ID:		
Required Date:	12/17/13	Req'd Qty: 12.00	*12*	Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2893	C								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA081 2-Debur								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

 13/12/24 ^{DAS}_{08 2-89} 12  

 13/12/24 ^{DAS}_{08 2-89} 12  

 13-12-30 12 

Work Order ID 110145***110145***

Page 2

December-17-13 9:16:10 AM

Item ID: D2893-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 12/17/13

Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/17/13

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.

12

0

0

14-1-2

140

0.00

140

QC

QC3- Inspect Part Finish

Memo

0.00

Quality Control

12

14-01-03

170

0.00

170

Packaging

Identify as per dwg & Stock Location: X-tube

Memo

0.00

Packaging

Finishing

12

14-01-03

December-17-13 9:16:10 AM

110145

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/17/13 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 12/17/13 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

Q13-A-3

~~14-01-3~~

Picklist Print

December-17-13 9:16:06 AM

Page 1

Work Order ID: 110145

Parent Item: D2893-1

Parent Item Name: Support

Start Date: 12/17/13

Required Date: 12/17/13

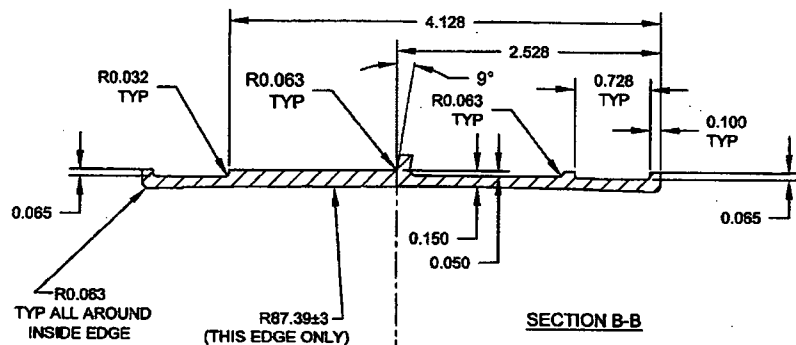
Start Qty: 12.00

Required Qty: 12.00

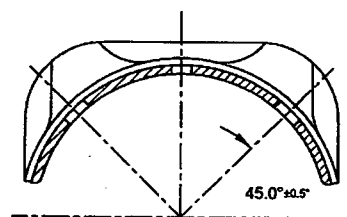
Comments: IPP: C02.11.26Reformat; Added P/OKJ
 IPP D 06.04.19 removed alodine EC
 IPP Rev:E Added priming as per Rev B 07-04-30 JLM
 IPP F 08.03.19 Re-format EC verified by: DD
 IPP Rev:G 08-05-15 add QC14 DD verified by:EC
 rev.C DD verf:EC
 IPP Rev:H 11.08.04 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	20.0000	0.5	6.3157896		SL 13-12-22	
D2893-1 Turning Detail													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT060		20							
				108383		10							
				109148		10							

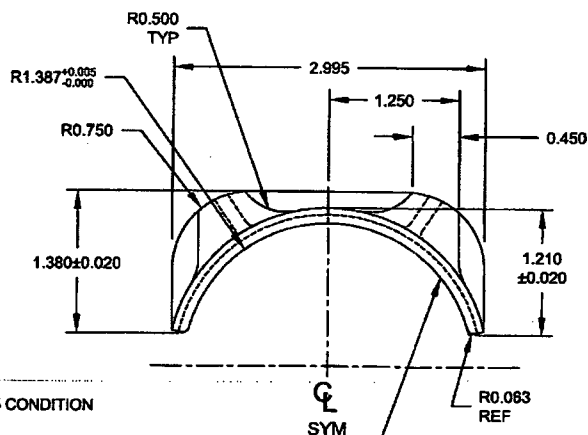
8 7 6 5 4 3 2 1



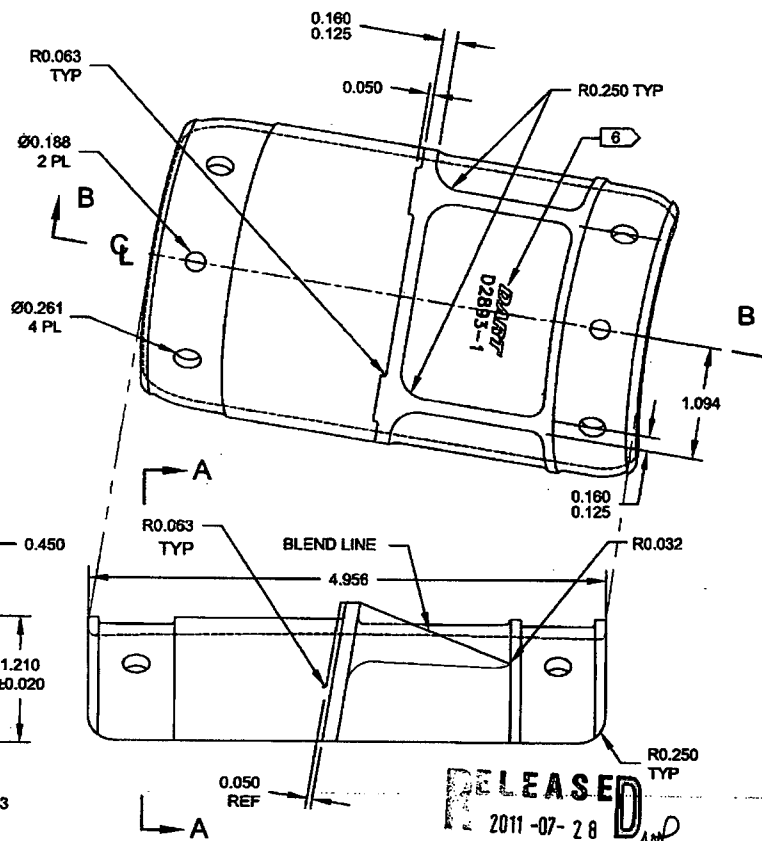
SECTION B-B



SECTION A-A
TOOLING HOLE DETAIL



D2893-1 SUPPORT



NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.JXXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK
(OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A
ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2893	REV. C SHEET 1 OF 1
TITLE Ø2.750 SUPPORT	SCALE NTS
COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

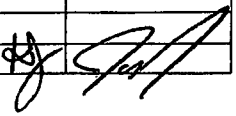
FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	2.985	3.005						
AB	0.440	0.460						
AC	0.125	0.160						
AD	0.040	0.060						
AE	0.188	0.193						
AF	0.125	0.160						
AG	0.140	0.160						
AH	1.360	1.400						
AI	0.040	0.060						
AJ	1.190	1.230						
AK	0.010	0.020						
AL	0.053	0.073						
AM	0.240	0.260						
AN	2.518	2.538						
AO	84.39	90.39						
AP	0.261	0.266						
AQ	0.053	0.073						
AR								
AS								
AT								
Accept/Reject								

Measured by:	Date:
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Audited by:	Date:
--------------------	--------------

Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	110145
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

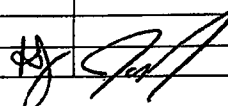
FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.997	2.997	2.996	2.997	2.997
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.150	.155	.148	.148	.148
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.151	.149	.148	.148	.147
AH	1.360	1.400		1.377	1.375	1.376	1.375	1.374
AI	0.040	0.060		.054	.056	.055	.053	.053
AJ	1.190	1.230		1.219	1.221	1.220	1.218	1.216
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: SL **Date:** 13-12-23

Audited by: SL **Date:** 13-12-30

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	110145
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	2.985	3.005		2.997	2.992	2.997	2.996	2.992
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.148	0.142	0.142	0.142	0.142
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.147	0.148	0.150	0.150	0.150
AH	1.360	1.400		1.374	1.378	1.379	1.380	1.379
AI	0.040	0.060		.055	0.052	0.049	0.051	0.050
AJ	1.190	1.230		1.218	1.222	1.220	1.221	1.219
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	SL / B. A. (Signature)	Date:	13-12-23
Audited by:	SL (Signature)	Date:	13-12-30
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	(Signature)

DART AEROSPACE LTD		Work Order:	110 145
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	7	4	6
HAAS Section								
AA	2.985	3.005		2.996	2.996			
AB	0.440	0.460		0.440	0.440			
AC	0.125	0.160		0.142	0.142			
AD	0.040	0.060		0.050	0.050			
AE	0.188	0.193		0.188	0.188			
AF	0.125	0.160		0.140	0.140			
AG	0.140	0.160		0.148	0.149			
AH	1.360	1.400		1.379	1.377			
AI	0.040	0.060		0.050	0.050			
AJ	1.190	1.230		1.218	1.2165			
AK	0.010	0.020		0.015	0.015			
AL	0.053	0.073		0.063	0.063			
AM	0.240	0.260		0.250	0.250			
AN	2.518	2.538		2.530	2.530			
AO	84.39	90.39		87.39	87.39			
AP	0.261	0.266		0.261	0.261			
AQ	0.053	0.073		0.063	0.063			
AR								
AS								
AT								
Accept/Reject								

Measured by:	B. A. 108	Date:	13/12/24
Audited by:	St	Date:	13-12-30
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
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